

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019272**Date Inspected:** 13-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector Brett W Rice was present during the times noted above for observations relative to the work being performed at ZPMC.

Bay 14 West

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Li Yan Hua.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3013AU

Weld No: 083 and 084

Welder: 066239

WPS-B-T-2133-ESAB

PCMK: SEG3013AU

Weld No: 065

Welder: 066239

WPS-B-T-2233-ESAB

PCMK: SEG-3013AW

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Weld No: 061 and 063
Welder: 066421
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Li Yan Hua.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3013AA
Weld No: 105
WR: 20130
Welder: 037780
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3013AA
Weld No: 055, 056, and 057
WR: 20128
Welder: 067765
WPS-345-SMAW-4G(4F)-FCM-Repair

PCMK: DP-3175-001
Weld No: 007 and 040
Welder: 067611
WPS-B-P-2212-TC-U4B-FCM-1

Bay 14 East

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhong Guo Hui.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3007K
Weld No: 038
WR: 19066
Welder: 216086
WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3007Q
Weld No: 148, 167, 174, and 177
WR: 20135
Welder: 215553

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WPS-345-SMAW-3G(3F)-FCM-Repair

PCMK: SEG-3019D

Weld No: 323

CWR: 2678

Welder: 066416

WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SEG-3007X

Weld No: 011, 012, 017, 018, 087, and 088

Welder: 067571

WPS-B-P-2112-FCM

PCMK: SEG-3019G

Weld No: 201 and 202

Welder: 037723

WPS-B-P-2114-TC-U4B-FCM-1

PCMK: SEG-3019J

Weld No: 012

Welder: 067656

WPS-B-P-2213-TC-U4B-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Zhong Guo Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

PCMK: SEG-3019E

Weld No: 164 and 165

Welder: 066763

WPS-B-T-2231-ESAB

PCMK: SEG-3007AV

Weld No: 088

Welder: 066733

WPS-B-T-2233-ESAB

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ma Qian Li.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

PCMK: SB-022-106

Weld No: 005

CWR: 2727

Welder: 066155

WPS-345-SMAW-2G(2F)-FCM-Repair

PCMK: SB-025-108

Weld No: 001

CWR: 2731

Welder: 259566

WPS-345-SMAW-1G(1F)-FCM-Repair

PCMK: SB-023-106

Weld No: 004

CWR: 2747

Welder: 066418

WPS-345-SMAW-3G(3F)-FCM-Repair



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Rice,Brett

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer